

Date: Monday, 12/01/2009 2:37:44 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER
Job Number :	44678		
Estimate Number :	13055		
P.O. Number :		Part Number :	D36541
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3654 REV.B
First Issue :	/ /	Project Number :	N/A
Previous Run :	43923	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	06/02/2009
Written By :		Qty:	4 Um: Each
Checked & Approved By :	JLD 09.01.13		
Comment :	Est Rev:A New Issue 07-10-29 DD verified by: EC Est Rev:B ecn1162 08-04-02 DD verified by:ec Est Rev:C 08-09-17 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.3675 sf(s)/Unit Total : 1.4700 sf(s)
 304/316 SS sheet 16 ga (0.063" thick)
 Batch: 110551 RB 9-2-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3654
 Dwg Rev: B
 Prog Rev: B

RB 9-2-3

2-Deburr if necessary

RB 9-2-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RB 9-2-3

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and stock
 Location: 5/182

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:37:44 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 44678

Part Number: D36541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/04
JD

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11 09-02-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>44678</u>
Description: Doubler		Part Number: D3654-1
Inspection Dwg: D3654	Rev: A	Page 1 of 1

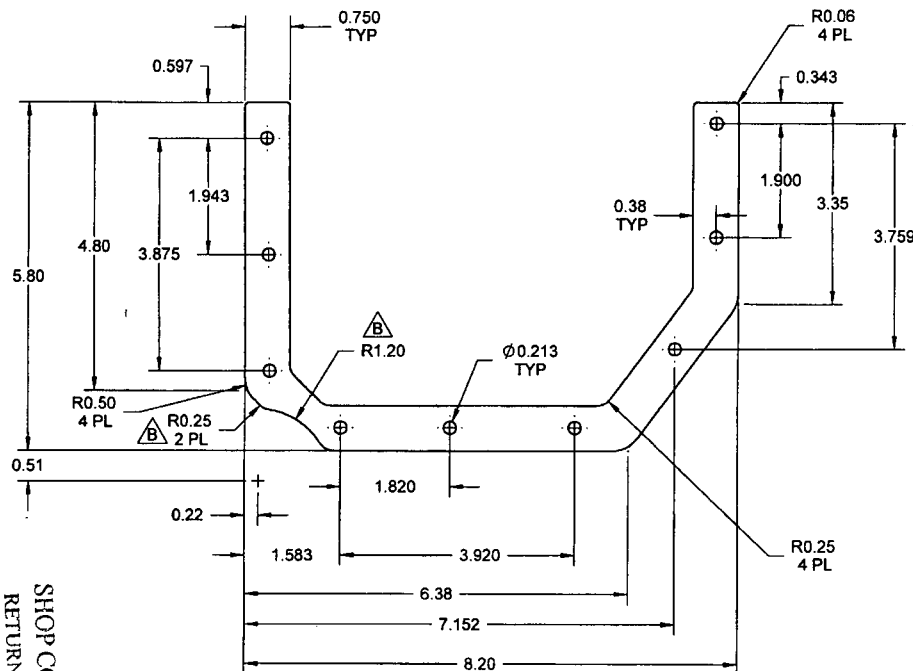
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.213	+0.005/-0.001	0.216	X			
0.750	+/-0.010	0.759	X			
1.943	+/-0.010	1.940	X			
0.597	+/-0.010	0.598	X			
3.875	+/-0.010	3.871	X			
4.80	+/-0.030	4.80	✓			
5.80	+/-0.030	5.786	X			
3.43	+/-0.030	3.340	✓			
1.900	+/-0.010	1.894				
3.35	+/-0.030	3.34	X			
3.759	+/-0.010	3.757	✓			
1.00	+/-0.030					
1.583	+/-0.010	1.581	✓			
1.820	+/-0.010	1.816	X			
3.920	+/-0.010	3.922	✓			
6.38	+/-0.030	6.38	✓			
7.152	+/-0.010	7.159	X			
8.20	+/-0.030	8.268	X			

Measured by: <u>UB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-2-3</u>	Date: <u>09/02/04</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	<u>[Signature]</u>



D3654-1 DOUBLER

RELEASED
08.09.11

SHOP COPY
ENGINEERING
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
NO. 146078

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.063 (16 GAUGE) SHEET PER AMS 5513/5524 (REF. DART SPEC. M304S16GA) B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3654-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

B	ADD R1.20 & R0.25 (ZN C6); MATERIAL NOTE AMS 5513/5524 WAS MIL-S-5019 (ZN A6); REFORMATTED DRAWING TO CURRENT STANDARD	RF	08.09.11
A	NEW ISSUE	RF	07.11.07
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3654	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.09.11	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	